Work Orde Wednesday, May												
Revision ID: Item Name:	D3644-1 Shim 5/19/2010	Start Qty: 6.00		Accept	Cust Item I			Setup S	1 188			
Required Date: 5 Reference:	5/26/2010	Req'd Qty: 6.00			Customer:	.						
_	Process Pla	nn:	Date: 0-5-19	Tooling: SPC (Y/N):		te:			tart top			
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Draw Number	Draw Pla Rev. Coo		t Reject Qty	Rejec Numb			
Draw Nbr D3644	Rev Rev	ision Nbr A					MAT	TOLA	~ 1 \ A \ \	^		
Waterjet FLOW CNC Waterjet	55	FLOW WATER JET Memo 1-Cut as pe Deburr if n	er Dwg D3644 Dwg Rev:	0.00 A _□Prog Rev:_ (3 35 32	<u>A</u> 🖂		R	NOT (- 2 (1			
110 		QC2- Inspect parts off r	nachine FAI/FAIB	0.00			_(-8	10-6-	>			
120 		QC8- Inspect parts - sec	ond check	0.00	Soloclo	2		She	10/06	/02 (3)		

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								1 100 mg.	
			·						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:				ER NON-CONFORMA					
DATE	STEP	Description of NC		Corrective Action Secti		Verific	cation	Approval	Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti		Chief Eng	QC Inspector
									-
							,		
!									ľ

Work Order ID 58835

Wednesday, May 19, 2010 1:08:35 PM



Page 2

Item ID:

D3644-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Shim **Item Name:**

Required Date: 5/26/2010

QC:

5/19/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Start Run

Stop

Sequence ID/ **Work Center ID**

130

HandFinish

Hand Finishing

Operation **Description**

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/ **Run Hours**

Draw Number Rev.

Date:

Plan Code Accept **Qty**

Reject

Reject Insp. Number Stamp

0.00

0.00 = 7 m/ W/06/07

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

X15 Ø

150

Packaging

Identify as per dwg & Stock Location: 243

Memo

0.00

Packaging

0.00

W/O:			W	ORK ORDER CHANG	SES				-	
DATE	STEP	PRO	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	:									
· · · · · · · · · · · · · · · · · · ·			ŀ							
Part No	•	DAD #-	Fault Cata		NOD. V		. 50	_		
· urt reo		PAR #: esolution:								
NCR:		T		ER NON-CONFORM					Date:	
	T						<u> </u>			<u> </u>
DATE	STEP	Description of NC Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
,61,41										
										ŀ

Work Order ID 58835

Wednesday, May 19, 2010 1:08:35 PM



Page 3

Item ID:

D3644-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Required Date: 5/26/2010

Shim

5/19/2010

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:	
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Process Plan:

Date:_____

Tooling:

Date:

Run Start

QC:__

Date:_____

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Operation Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

Draw Number

Plan Draw Rev. Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

QC

Memo

0.00

0.00

10/06/09 75 onf 10-6-9

Quality Control

W/O:			WC	ORK ORDER CHANC	GES				
DATE	STEP	PRO	OCEDURE CHA	Ву	Dat	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Cated	orv.	NCP: Vo	s No	DOA:	Data	
	R	esolution:	Disposition	1:	QA: N/C	Closed:	DQA	_ Date: _ Date: _	
NCR:				ER NON-CONFORM					
DATE	TE STEP Description of NC Corrective Action				V			Approval	Approval
	0,2,	Section A	Initial Action Descr Chief Eng Chief Eng		Sigr Da	1 &	Section C	Chief Eng	QC Inspector
	-								
								<u></u>	
							·		
								:	

Picklist Print

Wednesday, May 19, 2010 1:08:39 PM

Work Order ID: 58835

Parent Item:

Comments:

D3644-1

Parent Item Name:

Shim

IPP Rev:A New Issue 07-07-20 JLM

Verified By:EC

Start Date: 5/19/2010

Required Date: 5/26/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050	 	Purchased	No			110	sf	33.9947	0.1664	91		
2024-T3 050 sheet											1810-6-2	

2024-T3 .050 sheet

Location	Loc Oty	Loc Code		
MAT22	33.9947			(15)
111381	30.9			
112291	2.7		117291	
113189	0.3947			

Page 1

	-									
W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE						Approval Chief Eng / Prod Mgr	Approval QC Inspector
										
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ	A :	Date:	
		esolution:								
NCR:			WORK ORDI	ER NON-CONFORMA	NCE ((NCR)				
DATE	STEP	Description of NC	scription of NC Corrective Action				Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Date		Section C		Chief Eng	QC Inspector
									į	
<u> </u>				-						
						-				

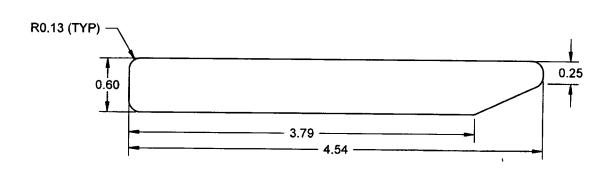
DART AEROSPACE LTD	Work Order:	58835
Description: Shim	Part Number:	D3644-1
Inspection Dwg: D3644 Rev: A		Page 1 of 1

	FIRS	ST ARTICLE II	NSPECTION	ON CHE	CKLIST		
	r	X First Arti		Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
0.60	+/-0.030	(603)	ك				
3.79	+/-0.030	3,792	*				
4.54	+/-0.030	4.543	b				-
0.25	+/-0.030	.95	8				
R0.13	+/-0.030	13	\ E				
0.050	+/-0.010	,048	٧			<u> </u>	
						7**	
,							
1							
						·	
Measured by:	ı D	Audited by:	.01		Prototype App	rovali	N/A
Date:	18-6-2	Date:	118/101-1	42	· /	Date:	N/A

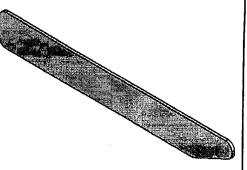
Meas	ured by:	13	Audited by:	Dh.		Prot	otype Approval:	N/A
	Date:	10-6-2	Date:	10/06	102.1		Date:	N/A
				. 1 - 1		0,010	6112	
Rev	Date	Change					Revised by	Approved
A	07.10.25	New Issue					KJ/EC/DD	- 13/

Dart Aerospace I	Ltd
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W/O:		WORK ORDER CHANGES											
DATE STEP		PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								·					
							,						
Part No:		PAR #:	AR #: Fault Category:				NCR: Yes No DQA: Date:						
	Re	esolution:	tion: Disposition:				QA: N/C Closed: Date:						
NCR:			WORK ORI	DER NON-CONFORM	IANCE	(NCR)	•••					
DATE	STEP	Description of NC			ction B		Verific	Verification	Approval	Approval			
	Section A		Initial Chief Eng			Sign & Date	n & Section C		Chief Eng	QC Inspector			
								4.					
						i							



D3644-1 SHIM (REPLACES GENEVA P/N G10610-3)



SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER



NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3644-1" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.01lbs

	,							
Α	NEW IS	SUE; REPLACI	LE	07.07.27				
REV.			DESCRIPTION	BY	DATE			
DESIGN		DTI	DART AERO	SPACE USA	CE USA, INC.			
DRAW	N	CO	PORT HADLOCK, WA					
CHECK	ŒD	B	DRAWING NO.		REV. A			
MFG. APPR.		B	D3644		SHEET 1 OF 1			
APPRO	VED	140	TITLE		SCALE			
DE APF	PR.	9	SHIM		1:1			
DATE	07.0	7.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS OCCUMENT IS PRIVATE AND COMPROENTAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY CHIEF PERSON WITHOUT WHITTEN PERMISSION FROM DART AEROSPACE USA, INC.					

W/O:			W	ORK ORDER CH	IANGES							
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							even					
Part No	:	PAR #:	Fault Ca	tegory:	NC	NCR: Yes No DQA:				Date:		
			Disposition:									
NCR:		V	VORK OR	DER NON-CONF	ORMANCE	(NCR)					
DATE	STEP	EP Description of NC Section A	Corrective Action Section I Initial Action Description			Sign &		Verification	Approval	Approval		
			Chief Eng	Chief Eng	puon	Date	Secti	on C	Chief Eng	QC Inspector		